



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 174896



Part No: D350-591-312

Job Qty: 15 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 5/2/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea	4/28/18	4/28/18	0.00	0.00	Start Up Large Fab-4		14 2018-04-12
110	Large Fab	15 pcs	4/30/18	4/30/18	0.00	15.00	Large Fab 2		14 2018-04-12
120	QC	15 pcs	4/30/18	4/30/18	0.00	0.00	QC9	CPC	
130	QC	15 pcs	4/30/18	4/30/18	0.00	0.00	QC5	CPC	
140	HandFinish	15 pcs	4/30/18	4/30/18	0.00	2.81	HandFinish1		DER-18-04-17
150	QC	15 pcs	4/30/18	4/30/18	0.00	0.00	QC7-2	CPC	
180	Large Fab	15 pcs	5/1/18	5/1/18	0.00	15.00	Large Fab 2		38 2018-04-17
190	QC	15 pcs	5/1/18	5/1/18	0.00	0.00	QC10		38 2018-04-17
200	QC	15 pcs	5/1/18	5/1/18	0.00	0.00	QC5		38 2018-04-17
210	HandFinish	15 pcs	5/1/18	5/1/18	0.00	2.81	HandFinish1		SA 18-04-17 24
220	Powdercoat	15 pcs	5/1/18	5/1/18	0.00	4.46	Powdercoat1		BA 18-04-25
230	HandFinish	15 pcs	5/2/18	5/2/18	0.00	2.81	HandFinish3		BA 18-04-25
240	QC	15 pcs	5/2/18	5/2/18	0.00	0.00	QC3		11 APR 2 2018
250	Packaging	15 pcs	5/2/18	5/2/18	0.00	0.00	Packaging1-3		9 APR 2 2018
260	QC	15 pcs	5/2/18	5/2/18	0.00	0.00	QC4		11 APR 2 2018
265	DC	15 pcs	5/2/18	5/2/18	0.00	0.00	DC		11 APR 2 2018
270	Packaging	15 pcs	5/2/18	5/2/18	0.00	0.00	Packaging3-1		21 MAY 0 2018
280	QC21-FG	15 Ea	5/2/18	5/2/18	0.00	0.00	QC21		21 MAY 0 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138761 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138761 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:45 OVEN TEMPERATURE: 300 FINISH TIME: 12:15

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Wing walk M138761

Plex 3/22/18 3:40 PM Dart.Gagnon.Michelle

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate 5049922 → 9x	30 Ea (2 ea)	90-Start up Operation	5047606 → 6x 1x
D3219-1	Plate 5047627 → 20	30 Ea (2 ea)	90-Start up Operation	5050520 → 4x
D3272-1	Step 5050733 → 10x	15 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	15 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	30 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	240 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	30 Ea (2 ea)	250-Packaging	5078892
AN4-13A	Bolt	120 Ea (8 ea)	250-Packaging	5034119
AN5-36A	Bolt	30 Ea (2 ea)	250-Packaging	5041116 x 18 5048272 x 2
D2230-3	Mounting Lug	60 Ea (4 ea)	250-Packaging	5051382
D2618	Bushing	30 Ea (2 ea)	250-Packaging	5043411
D2856-400 → 20	Abrasion Strip 4" Wide (Per Foot)	18 Ea (1.2 ea)	250-Packaging	5046950
D3235-1	Mounting Lug	30 Ea (2 ea)	250-Packaging	5051314
D3278-041	Support Assembly	15 Ea (1 ea)	250-Packaging	5051875
MS21042L3	Nut	30 Ea (2 ea)	250-Packaging	5038068 52
MS21042L4	Nut	120 Ea (8 ea)	250-Packaging	5045901 x 16 5054118 x 64
MS21042L5	Nut	30 Ea (2 ea)	250-Packaging	5041167
NAS1149D0363J	Washer	60 Ea (4 ea)	250-Packaging	505269
NAS1149D0463J	Washer 5055752 x 178	240 Ea (16 ea)	250-Packaging	5045845 5054108 x 2
NAS1149D0563J	Washer	60 Ea (4 ea)	250-Packaging	5039035 x 127

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	30	79	0
	D3219-1	30	93	0
	D3272-1	15	10	0
180-Large Fab	D3065-041	15	1	0
	D3066-1	30	72	0
	MS20600-AD4W4	240	1,071	0
250-Packaging	AN3-35A	30	256	0
	AN4-13A	120	525	0
	AN5-36A	30	230	0
	D2230-3	60	191	0
	D2618	30	420	0
	D2856-400	18	48	0
	D3235-1	30	250	0
	D3278-041	15	19	0
	MS21042L3	30	2,638	0
	MS21042L4	120	2,392	0
	MS21042L5	30	696	0
	NAS1149D0363J	60	3,095	0
	NAS1149D0463J	240	3,234	0
	NAS1149D0563J	60	2,035	0

Part Specifications

Specifications could not be found.

M. U 002456

Plex 3/22/18 3:40 PM Dart.Gagnon.Michelle

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Container No: S060375



Part: D350-591-312

Job No: 174896

Serial No/Batch: S060375

Revision:

Inspector:

Date: 04/12/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002874	S066306	D2618	Bushing	S043411	ST008	20
002874	S061412	D2856-400-720	Abrasion Strip 4" X 7.20"	S046950	ST418	3
002874	S066305	D2856-400-720	Abrasion Strip 4" X 7.20"	S046950	ST418	17
002874	S066231	D3235-1	Mounting Lug	s051314	ST522	20
002874	S066230	D3278-041	Support Assembly	s059873	ST522	10
002874	S066226	MS21042L3	Nut	S006902	ST303	20
002874	S045901	MS21042L4	Nut		ST303	16
002874	S066225	MS21042L4	Nut	S054118	ST303	64
002874	S066224	MS21042L5	Nut	S041167	ST303	20
002874	S066204	NAS1149D0363J	Washer	s015269	ST263	40
002874	S054108	NAS1149D0463J	Washer		ST260A	19
002874	S066201	NAS1149D0463J	Washer	s055952	ST263	141
002874	S066200	NAS1149D0563J	Washer	s039036	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/28/18 6:31 AM dart.quirion.sonia

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							